

Work Order ID 74491




Monday, October 03, 2011 10:43:21 AM




Page 1



Item ID: D2432 Accept  Setup Start 
 Revision ID: Stop 
 Item Name: 206 (24") Bearpaw
 Start Date: 9/30/2011 Start Qty: 16.00  Cust Item ID:
 Required Date: 10/11/2011 Req'd Qty: 16.00  Customer:

Reference:

Approvals: Process Plan: M.L.S  Date: 11/10/03 Tooling: _____ Date: _____ Run Start 
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2432	Rev F3								
120		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	Cut Blank as per D2432 File								
130		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS I	Memo	0.00							
HAAS CNC vertical machine #1	1-Inspect material for defects or damage prior to machining 2-Machine as per Folio and Dwg D2432 Identify as D2432F 3-Deburr								
140		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

B11-11-09



B11-11-09

F.K. 11/12/06

F.K. 11/12/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74491

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Item ID: D2432

Accept



Setup Start



Revision ID:

Stop



Item Name: 206 (24") Bearpaw

Start Date: 9/30/2011 Start Qty: 16.00

Required Date: 10/11/2011 Req'd Qty: 16.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

only 11/12/08

12 10

Quality Control

151

Identify as per dwg & Stock Location: ST 495

0.00



Packaging

Memo

0.00

11-12-8

Packaging

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

11/12/8

Quality Control

11-12-08

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Picklist Print

Monday, October 03, 2011 10:43:26 AM

Page 1

Work Order ID: 74491

Parent Item: D2432

Parent Item Name: 206 (24") Bearpaw




Start Date: 9/30/2011

Required Date: 10/11/2011

Start Qty: 16.00

Required Qty: 16.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10 		Purchased	No			120	sf	457.6200	3.7	59.2		60. R 11-30	
UHMW 1" Black													

Location

Loc Qty

Loc Code

MAT018

357.62

117321

76.6

117738

124.3

117819

99.3

118257

57.42

ST

100

118814

100

117738 x 6 = 72.

118814 x 10 = 37

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	74491
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432	Rev: F3	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.063 x 45°				
B	5.500	+/-0.030	5.502				
C	0.200	+/-0.030	.192				
D	0.25 x 45°	+/-0.030	.25 x 45°				
E	R0.250	+/-0.030	.250				
F	0.250	+/-0.010	.245				
G	0.625	+/-0.030	.630				
H	0.375	+/-0.010	.378				
I	0.950	+0.030/0.010	.951				
J	19.000	+/-0.030	19.000				
K	3.14	+/-0.030	3.14				
L	3.28	+/-0.030	3.28				
M	Ø0.260	+0.005/-0.000	.260				
N	Ø0.93	+/-0.030	.929				
O	0.30	+0.030/-0.000	.321				
P	23.750	+/-0.030	23.750				
Q	7.375	+/-0.030	7.375				
R	4.250	+/-0.010	4.25				
S	2.000	+/-0.030	2.000				
T	9.000	+/-0.010	9.000				
U	9.000	+/-0.010	9.000				
V	0.375	+/-0.010	.377				

Measured by: <i>F.K.</i>	Audited by: <i>and</i>	Prototype Approval:	N/A
Date: <i>11/12/08</i>	Date: <i>11/12/08</i>	Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	P/O K10008/D206-559-015	KJ/RF <i>[Signature]</i>

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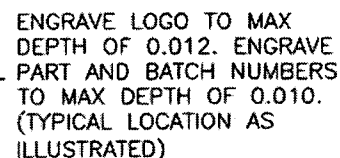
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NOTE: Date & initial all entries

98-06-17 KE



9143	
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~~Ø0.260 (TYP)~~ 
~~Ø0.75 C'BORE Ø0.93 C'BORE~~
~~0.35 DEEP FROM TOP (MIN.)~~
 0.30 DEEP FROM BOTTOM
~~(LEAVE 0.300 MIN.)~~ 
~~(LEAVE 0.650 MIN.)~~
 0.375 

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
1950 (REF)

EFFECTIVE	DEOS

FLAT PATTERN

BEND AFTER MACHINING
(D2432B ONLY)

D2432F: FLAT BEARPAW
D2432B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

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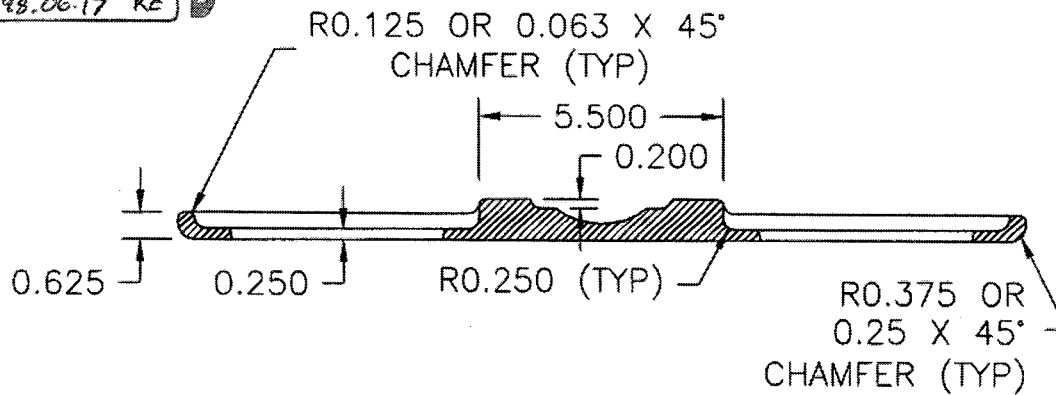
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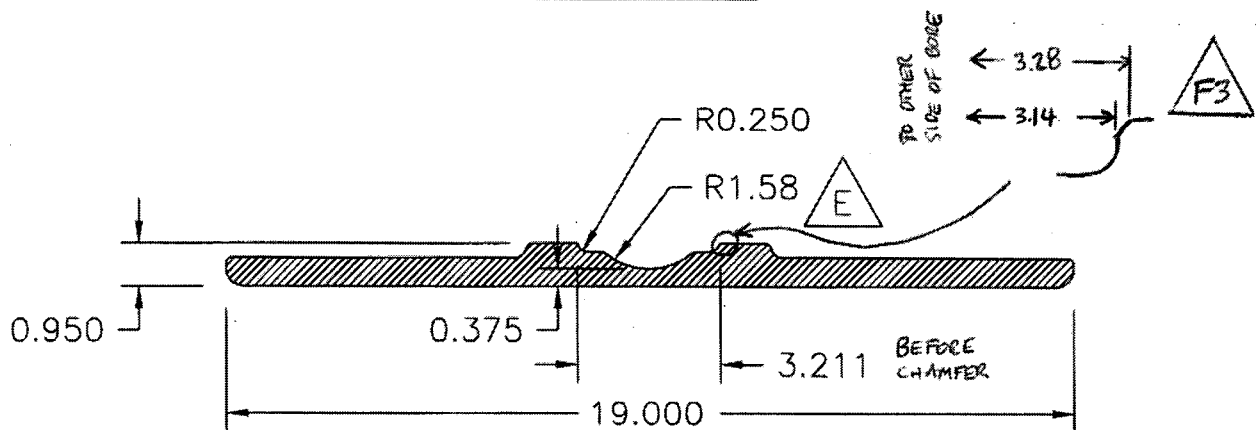


DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12		TITLE BEARPAW	SCALE 1:4

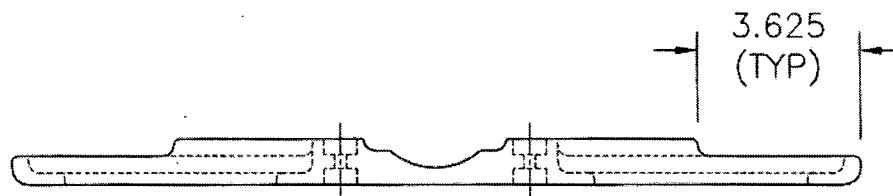
RELEASED
98.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

light

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